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D135-751-011
Job Sheet 201864



Part No: D135-751-011

Job Qty: 1 pcs

Part Name: Skidtube with Standard Wearplates Fits LH or RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/16/19

Job Tracking No:

Created By: Jennifer Renwick

Due Date: 11/29/19

Description: SIOP

Type: Stock

Note: DWG DSI 9661 REV A, D3507.REV D IPP Rev:A 44353 New Issue JLM IPP Rev:B 06-12-18 As per Rev B JLM IPP Rev:C 07-12-11 ECN 1036 as per revB DD IPP Rev D 08.11.04 Added DT9431 to sequence 5 EC verf DD IPP Rev E 10.02.22 per PAR 09-043 EC verified: DD IPP Rev:F 10.06.09 remove seq110 DD verf:EC IPP Rev G 10.09.17 added D3507-1-bent EC verified:DD IPP REV:H 13.12.11 ECN13-619/ CHG002 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
120	Skidtubes - 1	1 pcs	11/29/19		0.00	0.80	Skidtubes - 1		
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		TF
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
140	QC 5	1 pcs	11/29/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		



Container No: S224998



Part: D135-751-011

Job No: 201864

Serial No/Batch: S224998

Revision:

Inspector:

Exp Date:

Instructions: FAA STC SRD1709SE 18/10/17, LoA RDIMS

Dart Aerospace Ltd.
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CANADA
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150 Handfinish - 1-1 Chemical-B4B	1 pcs	11/29/19	0.00 0.33	QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
				Handfinish - 1 - 1 - B4B	BEB 19-10-22
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
160 QC 7	1 pcs	11/29/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	

				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
				QC 7 - 61	
				QC 7 - 81	
				QC 7 - 76	
				QC 7 - 79	
170 Skidtubes - 2 - B4B	1 pcs	11/29/19	0.00 1.00	Skidtubes - 1 - B4B	DD
			DD 1.04	Skidtubes - 2 - B4B	DD
				Skidtubes - 3 - B4B	
				Skidtubes - 4 - B4B	
				Skidtubes - 5 - B4B	BE
				Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
180 QC 10	1 pcs	11/29/19	0.00 0.00	QC 10 - 10	
				QC 10 - 18	
				QC 10 - 24	
				QC 10 - 43	
				QC 10 - 50	
				QC 10 - 58	
				QC 10 - 9	
				QC 10 - 68	
185 Handfinish - 6-1- Touch Up- B4B	1 pcs	11/29/19	0.00 0.10	Handfinish - 6 - 1 - B4B	OCT 28 2019 DAS 68
				Handfinish - 6 - 2 - B4B	9-89
				Handfinish - 6 - 3 - B4B	★ OCT 29 2019
				Handfinish - 6 - 4 - B4B	
				Handfinish - 6 - 5 - B4B	
				Handfinish - 6 - 6 - B4B	
				Handfinish - 6 - 7 - B4B	
				Handfinish - 6 - 8 - B4B	
				Handfinish - 6 - 9 - B4B	
				Handfinish - 6 - 10 - B4B	
				Handfinish - 6 - 11 - B4B	
				Handfinish - 6 - 12 - B4B	
				Handfinish - 6 - 13 - B4B	
				Handfinish - 6 - 14 - B4B	
				Handfinish - 6 - 15 - B4B	
				Handfinish - 6 - 16 - B4B	
				Handfinish - 6 - 17 - B4B	
				Handfinish - 6 - 18 - B4B	
				Handfinish - 6 - 19 -	

				B4B	
				Handfinish - 6 - 20 - B4B	
				Handfinish - 6 - 21 - B4B	
				Handfinish - 6 - 22 - B4B	
187 QC 7	1 pcs	11/29/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
				QC 7 - 61	
				QC 7 - 81	
				QC 7 - 76	
				QC 7 - 79	
190 Skidtubes - 3 - B4B	1 pcs	11/29/19	0.00 0.77	Skidtubes - 1 - B4B	
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	
				Skidtubes - 4 - B4B	
				Skidtubes - 5 - B4B	
				Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
200 QC 5	1 pcs	11/29/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	

					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	DAS OCT 29 2019 68 9-89
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
210 Handfinish - 2-1 Pressure- B4B	1 pcs	11/29/19	0.00 0.08		Handfinish - 2 - 1 - B4B	
					Handfinish - 2 - 2 - B4B	
					Handfinish - 2 - 3 - B4B	
					Handfinish - 2 - 4 - B4B	
220 Spray Paint - 2 - B4B	1 pcs	11/29/19	0.00 0.25		Spray Paint - 1 - B4B	
					Spray Paint - 2 - B4B	
					Spray Paint - 3 - B4B	
					Spray Paint - 4 - B4B	
225 QC 14	1 pcs	11/29/19	0.00 0.00		QC 14 - 15	
					QC 14 - 2	
					QC 14 - 34	
					QC 14 - 41	
					QC 14 - 51	
					QC 14 - 58	
					QC 14 - 59	
					QC 14 - 9	
					QC 14 - 68	
					QC 14 - 40	
					QC 14 - 19	
					QC 14 - 43	
					QC 14 - 24	
					QC 14 - 61	
					QC 14 - 81	
260 Handfinish - 4-1-Assembly- B4B	1 pcs	11/29/19	0.00 0.74		Handfinish - 4 - 1 - B4B	
					Handfinish - 4 - 10 - B4B	
					Handfinish - 4 - 11 - B4B	
					Handfinish - 4 - 12 - B4B	
					Handfinish - 4 - 13 - B4B	
					Handfinish - 4 - 14 - B4B	
					Handfinish - 4 - 15 - B4B	
					Handfinish - 4 - 2 - B4B	
					Handfinish - 4 - 3 - B4B	
					Handfinish - 4 - 4 - B4B	
					Handfinish - 4 - 5 - B4B	
					Handfinish - 4 - 6 - B4B	
					Handfinish - 4 - 7 - B4B	
					Handfinish - 4 - 8 - B4B	
					Handfinish - 4 - 9 - B4B	
270 QC 5	1 pcs	11/29/19	0.00 0.00		QC 5 - 10	
					QC 5 - 12	

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						QC 5 - 17	
						QC 5 - 18	
						QC 5 - 19	
						QC 5 - 22	
						QC 5 - 24	
						QC 5 - 3	
						QC 5 - 43	
						QC 5 - 49	
						QC 5 - 51	
						QC 5 - 58	
						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	OCT 31 2019 DAS 40 9-89
						QC 5 - 61	
						QC 5 - 81	
280	Packaging 1-1 - Pick Kit - B4B	1 ✓	11/29/19	0.00	0.00	Packaging 1 - 1 - B4B ✓	
	pcs					Packaging 1 - 2 - B4B	
						Packaging 1 - 3 - B4B ✓	
						Packaging 1 - 4 - B4B	
						Packaging 1 - 5 - B4B	
						Packaging 1 - 6 - B4B	
						Packaging 1 - 7 - B4B	
						Packaging 1 - 8 - B4B	
						Packaging 1 - 9 - B4B	
						Packaging 1 - 10 - B4B	
						Packaging 1 - 11 - B4B	
						Packaging 1 - 12 - B4B	
						Packaging 1 - 13 - B4B	
						Packaging 1 - 14 - B4B	
						Packaging 1 - 15 - B4B	
						Packaging 1 - 16 - B4B	
						Packaging 1 - 17 - B4B	
						Packaging 1 - 18 - B4B	
						Packaging 1 - 19 - B4B	
						Packaging 1 - 20 - B4B	
						Packaging 1 - 21 - B4B	
						Packaging 1 - 22 - B4B	
						Packaging 1 - 23 - B4B	
						Packaging 1 - 24 - B4B	
						Packaging 1 - 25 - B4B	
						Packaging 1 - 26 - B4B	
						Packaging 1 - 27 - B4B	
						Packaging 1 - 28 - B4B	
						Packaging 1 - 29 - B4B	
						Packaging 1 - 30 - B4B	
						Packaging 1 - 31 - B4B	
						Packaging 1 - 32 - B4B	
						Packaging 1 - 33 - B4B	
						Packaging 1 - 34 - B4B	
						Packaging 1 - 35 - B4B	
						Packaging 1 - 36 - B4B	
290	QC 4	1	11/29/19	0.00	0.00	QC 4 - 28	
	pcs						

Oscar

OCT 31 2019

				QC 4 - 58	
				QC 4 - 69	
				QC 4 - 9	
				QC 4 - 46	
				QC 4 - 68	
				QC 4 - 72	
				QC 4 - 74	DAS
				QC 4 - 75	78 OCT 31 2019
				QC 4 - 78	9-89
300 Packaging 3-1 - Stock - B4B	1 pcs	11/29/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	DAS
				Packaging 3 - 26 - B4B	78
				Packaging 3 - 27 - B4B	9-89 OCT 31 2019
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	DAS
305 DC - 1 - B4B	1 pcs	11/29/19	0.00 0.00	DC - 1 - B4B	21
				DC - 2 - B4B	9-89 OCT 31 2019
310 QC 21 - FG	1 pcs	11/29/19	0.00 0.00	QC 21 - FG - 21	DAS
				QC 21 - FG - 70	21
				QC 21 - FG - 53	9-89 OCT 31 2019

Part Op 120 - 1-Cut Aft end as per dwg D3507 3-Drill Aft & Fwd Cap holes using DT8678 & DT8901 4-Locate DT8870 & Drill
Descriptions: Ground wire hole on top of Tube. 6-Locate DT8870 with #30 cleco in Ground wire hole ,then Pilot Drill all X-Bolt holes using #30" drill.****DO NOT OPEN AFT CAP HOLES***** 7-Open crossbolt holes to 0.3125" (3 per side). Drill pilot holes for wearplates using Dt8868,Use DT8892 FOR REAR WEARPLATE HOLES. 8-Open six rear wearplate holes using DT8892.Open all wearplate holes to 0.297" 9-Open ground wire hole .297" section E-E 10-Open Aft & Fwd Cap holes

using .208" drill. 11-Bore out aft end of tube as per Dwg D3507 & Detail "B". 12- Section G-G holes must be laid out manually, open to #30. 13-Deburr holes.

140 - (QC5- Inspect part completeness to step on W/O)

160 - (QC7-Inspect Chemical Conversion Coat)

170 - 1-Open X-Bolt holes to .375" (1 Places) & .500" (2 Places) as per Dwg D3507. and section G-G to .750" (2 places) 2-Counter Sink X-BOLT holes as per Dwg D3507 3-Deburr and blow out chips from inside of tube. 4-Bond web as per Dwg D3507 & QSI 015 start time: 520025 end time: 01051000 5-Weld x-bolt spacers as per Dwg D3507 and Detail C-C & D-D and G-G 7-Drill Rivet Holes as per Dwg D3507 Using Dt8871A&B 8-Deburr Rivet holes.

180 - (QC10- Inspect visual per QSI004- ground welds)

185 - (Touch up alodine) RE-ALODINE ONLY

187 - (QC7-Inspect Chemical Conversion Coat)

190 - 1-Rivet D3506-1/-3 as per Dwg D3507.

200 - (QC5- Inspect part completeness to step on W/O)

210 - Touch-up alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

220 - (Spray Paint / NDT Room) 1- Apply Primer as per QSI 005 4.2.1.3.3 and dwg A/R Primer

Batch: _____ 2- Paint two coats of White paint as per QSI 005 4.2 and dwg A/R Paint

Batch: _____

225 - (QC14- Inspect Spray Paint)

260 - 1- Install Wearplate & Ground Wire inserts as per Dwg D3507. 1-Inspect for Foreign objects 2-Install Fwd & Aft caps as per Dwg D3507 And Detail "A" & "B" 3-Install Wearplates as per Dwg D3507 , Note:Install (1) Bolt and (1) washer on Ground Wire insert on top of tube Do not Install Screws where indicated on Dwg(Note #6) 4-assemble o'ring to plug as per dwg D3492 and apply o'ring tube 5- Wing Walk as per Dwg D3507 and QSI 005 4.4 Batch: 5209362

270 - (QC5- Inspect part completeness to step on W/O)

280 - (Pick Kit)

290 - (QC4- 100% Inspect kits for completeness)

300 - (Identify as per dwg & Stock Location: _____) Identify and pack for shipping as per PPP D135-751-011 PPP

Rev: _____

305 - Photocopy bluefile & type labels per PPP D135-751-011 CHG002

310 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3507-1-BENT	Skidtube Assembly EC135	1 pcs (1 ea)	120-Skidtubes - 1	5166847
D3504-1	Crossbolt Spacer	2 pcs (2 ea)	170-Skidtubes - 2 - B4B	5146029
D3504-3	Crossbolt Spacer	1 pcs (1 ea)	170-Skidtubes - 2 - B4B	5167825
D3504-5	Crossbolt Spacer	2 pcs (2 ea)	170-Skidtubes - 2 - B4B	5222140
D3505-1	Web	1 pcs (1 ea)	170-Skidtubes - 2 - B4B	5154725
D3506-1	Doubler	4 pcs (4 ea)	190-Skidtubes - 3 - B4B	5218749
D3506-3	Doubler	2 pcs (2 ea)	190-Skidtubes - 3 - B4B	5189442
MS20601-AD4W3	Rivet	12 Ea (12 ea)	190-Skidtubes - 3 - B4B	5222593
ALS4-1032-225	Rivnut	1 Ea (1 ea)	260-Handfinish - 4-1-Assembly-B4B	5203363
ALS7-1032-130	Rivnut	38 Ea (38 ea)	260-Handfinish - 4-1-Assembly-B4B	5209191
AN3C4A	Bolt	31 Ea (31 ea)	260-Handfinish - 4-1-Assembly-B4B	5217800
AN3C5A	Bolt	2 Ea (2 ea)	260-Handfinish - 4-1-Assembly-B4B	5225291
AN526C1032R10	Screw	2 Ea (2 ea)	260-Handfinish - 4-1-Assembly-B4B	5166981
D2965	Cap	1 pcs (1 ea)	260-Handfinish - 4-1-Assembly-B4B	5166570
D2965-3	Cap	1 pcs (1 ea)	260-Handfinish - 4-1-Assembly-B4B	5166571
D3492-1	Plug	4 pcs (4 ea)	260-Handfinish - 4-1-Assembly-B4B	5218656
D3492-3	Plug	4 pcs (4 ea)	260-Handfinish - 4-1-Assembly-B4B	5218332
D3492-7	Plug	2 pcs (2 ea)	260-Handfinish - 4-1-Assembly-B4B	5148611
D4918-047	Wearplate Aft	1 pcs (1 ea)	260-Handfinish - 4-1-Assembly-B4B	5218949
D4918-1	Wearplate Fwd	1 pcs (1 ea)	260-Handfinish - 4-1-Assembly-B4B	5220080
D4918-3	Wearplate Center Fwd	1 pcs (1 ea)	260-Handfinish - 4-1-Assembly-B4B	5220102
D4918-5	Wearplate Center Aft	1 pcs (1 ea)	260-Handfinish - 4-1-Assembly-B4B	5220109
NAS1149C0332R	Washer (AN960C10L)	33 Ea (33 ea)	260-Handfinish - 4-1-Assembly-B4B	5218154
NAS1611-007	O-Ring	2 Ea (2 ea)	260-Handfinish - 4-1-Assembly-B4B	F103687
NAS1611-010	O-Ring	4 Ea (4 ea)	260-Handfinish - 4-1-Assembly-B4B	5217831
NAS1611-013	O-Ring	4 Ea (4 ea)	260-Handfinish - 4-1-Assembly-B4B	5217787
AN3C4A	Bolt	8 Ea (8 ea) ✓	280-Packaging 1-1 - Pick Kit - B4B	5090636
D3512-041	Wearplate	2 pcs (2 ea) ✓	280-Packaging 1-1 - Pick Kit - B4B	5227442 ✓
NAS1149C0332R	Washer (AN960C10L)	8 Ea (8 ea) ✓	280-Packaging 1-1 - Pick Kit - B4B	5218164 ✓

(012724)

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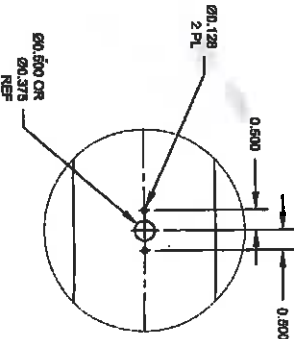
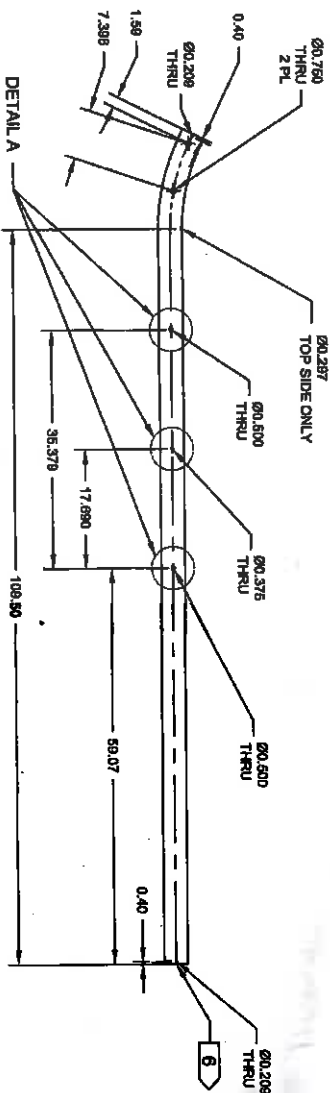
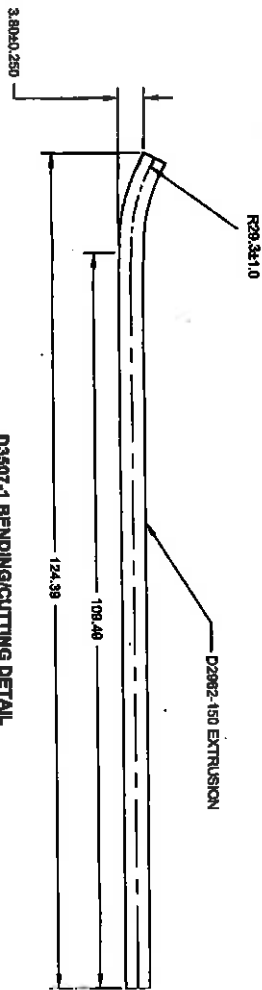
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
120-Skidtubes - 1	D3507-1-BENT	1	5	0
	D3504-1	2	114	0
	D3504-3	1	100	0
	D3504-5	2	30	0
	D3505-1	1	7	0
170-Skidtubes - 2 - B4B	D3506-1	4	21	0
	D3506-3	2	10	0
	MS20601-AD4W3	12	385	0
	ALS4-1032-225	1	1,519	0
	ALS7-1032-130	38	1,379	0
190-Skidtubes - 3 - B4B	AN3C4A	31	1,464	0
	AN3C5A	2	678	0
	AN526C1032R10	2	49	0
	D2965	1	50	0
	D2965-3	1	45	0
260-Handfinish - 4-1-Assembly-B4B	D3492-1	4	212	0
	D3492-3	4	143	0
	D3492-7	2	54	0
	D4918-047	1	14	0
	D4918-1	1	15	0
	D4918-3	1	20	0
	D4918-5	1	20	0
	NAS1149C0332R	33	3,786	0
	NAS1611-007	2	232	0
	NAS1611-010	4	151	0
280-Packaging 1-1 - Pick Kit - B4B	NAS1611-013	4	156	0
	AN3C4A	8	1,464	0
	D3512-041	2	9	0
	NAS1149C0332R	8	3,786	0
Part Specifications				
Specifications could not be found.				

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Qty	Part Number	Description
X	D3607-041	SHOETUBE ASSEMBLY
1	D2982-150	EXTRUSION
1	D2985	CAP
1	D2985-3	CAP
4	D3602-041	PLUG ASSEMBLY
4	D3602-043	PLUG ASSEMBLY
2	D3602-047	PLUG ASSEMBLY
2	D3604-1	CROSS BOLT SPACER
1	D3604-3	CROSS BOLT SPACER
2	D3604-5	CROSS BOLT SPACER
1	D3606-1	WEB
4	D3606-1	DOUBLER
2	D3606-3	DOUBLER
1	D4818-1	WEARPLATE
1	D4818-3	WEARPLATE
1	D4818-5	WEARPLATE
1	D4818-6/7	WEARPLATE
1	AE15-1032-150	INSERT
1	AE15-1032-225	INSERT
31	AN35-4A	BOLT
2	AN35-5A	BOLT
2	AN520C-1032-10	SCREW
33	AN520C-10L	WASHER
12	AN520C-10DAYS	RIVET

GENERAL NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART OSI 005 4.1 PRIOR TO INSERTING D3606-1 WEB.
- 3) STANDARD: PRIME (REF. 4.2 1.33) AND PAINT WHITE PER DART OSI 005 4.2.
- 4) OPTICAL: POWDER COAT WHITE (REF. 4.3 3.1) PER DART OSI 005 4.2.
- 5) BLACK PAINT: POWDER COAT WHITE (REF. 4.3 3.1) PER DART OSI 005 4.2.
- 6) DART OSI 005 4.1 (REF. 4.3 3.1) PER DART OSI 005 4.2.
- 7) TO DIMENSIONS: INCHES, UNLESS OTHERWISE NOTED
- 8) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 9) IDENTIFICATION: IDENTIFY WITH DART BN PER DART OSI 04 6.4 (VIBRATING STYLUS) ON ID. OF TUBE.
- 10) WEIGHT: 24.1 LB (FROM IIN-D136-781)
- 11) WEIGHING TO BE DONE PER DART OSI 004
- 12) INSERT D3606-1 WEB TO LOCATION SHOWN OFF AFT END OF SHOETUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL STRAFLUX-241/281 ADHESIVE PER DART OSI 015 AFTER BENDING
- 13) USE DART DRILL TEMPLATE TO LOCATE AND DRILL 90.287 HOLE (5.08 PLACES) FOR WEARSHOE INSERTS, INSERT BOLTS WITH SHAFLEX-241/281.
- 14) AFTER FINISH, SEAL INSERTS, INSERT BOLTS WITH SHAFLEX-241/281.
- 15) DO NOT INSTALL AN35-4A BOLTS AND AN520C-10 WASHERS IN INDICATED LOCATIONS



DETAIL A
TYP. 6 PL
SCALE 3:10

D	REMOVE D3606-X GASKETS, DART B-X WAS D3606-X	DW	13.08.30
C	REVERSE FINISH TO ADD PAINT AS THE PREFERRED FINISH, REVISED NOTES	DC	07.08.19
B	ADD GASKET, CHANGE HARDWARE MATL	PH	06.11.01
A	NEW ISSUE	PH	06.04.21
DESIGN	DW	DESCRIPTION	DART AEROSPACE USA, INC
DRAWN	DW	DRAWING NO.	KENT, WA
CHECKED	DW	DATE	13.08.30
APPROVED	DW	TITLE	EC 135 SKIDTUBE
DATE	13.08.30	SCALE	NTS

20201020
RK ORDER
WITHOUT NOTICE
SUBJECT TO AMENDMENT
ENGINEERING
RETURN TO
SHOP

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

NCR No.

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐	
Date : _____		Sequence #: _____		QTY Affected : _____	
Description Work Order Deviation		Disposition			
Completed By		Lead hand / Supervisor			
QC / QA Coordinator		Positioned Wrong Outside Tolerance Drawing Finish Part Lost/Missing Misread			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐			
Other/Details:		Other/Details:			

5.0 PARTS LIST

Item	Qty -011	Qty -041	Qty -043	Qty -101	Part Number	Description
	X				D135-751-011	SKIDTUBE INSTALLATION
	1	X			D135-751-041	REPLACEMENT SKIDTUBE
			X		D135-751-043	WEARPLATE KIT
				X	D135-751-101	SKIDTUBE EXTENSION KIT
1		1			D3507-041	SKIDTUBE ASSEMBLY
2	4				**BRS8-96/48SZ-M8-W2	CLAMP
3	8				**LN9038-08032	SCREW
4		1			*D2965	CAP
5		1			*D2965-3	CAP
6		2			***AELS-1032-130	INSERT
7		2			***AELS-1032-225	INSERT
8		2			*AN3C5A	BOLT
9		2			*AN960C10L	WASHER
10		2			*AN526C1032-10	SCREW
20A		1	1		*D3508-1	WEARPLATE
20B		1	1		*D3558-1	GASKET
21A		1	1		*D3508-3	WEARPLATE
21B		1	1		*D3558-3	GASKET
22A		1	1		*D3508-5	WEARPLATE
22B		1	1		*D3558-5	GASKET
23A		1	1		*D3508-7	WEARPLATE
23B		1	1		*D3558-7	GASKET
24		38			*AELS-1032-130	INSERT
25		30	38		*AN3C4A	BOLT
26		30	38		*AN960C10L	WASHER
27			2		D3512-1	WEARPLATE
30		1			*AELS-1032-225	INSERT
31		1			*AN3C4A	BOLT
32		1			*AN960C10L	WASHER
40		4			*D3492-041	PLUG ASSEMBLY
41		4			***NAS1611-010	O-RING
42		2			*D3492-047	PLUG ASSEMBLY
43		2			***NAS1611-007	O-RING
44		4			*D3506-1	DOUBLER
45		8			*MS20601AD4W3	RIVET
46		2			*D3506-3	DOUBLER
47		4			*MS20601AD4W3	RIVET
48		4			*D3492-043	PLUG ASSEMBLY
49		4			***NAS1611-013	O-RING
50				1	D3510-041	INSERT ASSEMBLY
51				2	***AELS-1032-130	INSERT
52				6	***AELS-1032-225	INSERT
53				2	***ALS4-428-165	INSERT
54				2	AN4C7A	BOLT
55				2	AN960C416L	WASHER
56				2	AN3C4A	BOLT
57				8	AN3C7A	BOLT
58				10	AN960C10L	WASHER

* PART IS INCLUDED WITH D3507-041 SKIDTUBE ASSEMBLY

** TO BE SUPPLIED BY CUSTOMER, LISTED AS REFERENCE ONLY

*** DENOTES PART IS INCLUDED WITH ASSEMBLY ABOVE

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Revision: C

Date: 07.09.20